

Date: Thursday, 20/11/2008 3:37:07 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 43649		
Estimate Number	: 11178		
P.O. Number	:	Part Number	: D32931
This Issue	: 20/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3293 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 42028	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 21/12/2008
Checked & Approved By	: <u>JUL 08.11.21</u>	Qty:	10 Um: Each
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 1.9177 sf(s)/Unit Total : 19.1772 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick
 (M2024T3S.080)
 Identify for D3293-1
 Batch: 110347 **1B 8-12-23**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3293
 Dwg Rev: A
 Prog Rev: A

1B 8-12-23**(12)**

2-Deburr if necessary **1B 8-12-23**

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK**1B 8-12-23****(11) (P10)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/05
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-23	20	1 part is scrap. It has a 0.012" blow out along I hole about .5" long. Machine malfunction. R.C. Process	<u>[Signature]</u> BS142	Scrap: No replace	08/12/23 EF	<u>[Signature]</u> 08-12-23	<u>[Signature]</u> BS142	<u>[Signature]</u> 08-12-23

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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edges only



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Deburr

SP 08/12/23

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Job 12-23 (11)



Comment: INSPECT WORK TO CURRENT STEP

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(11X)

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

M-L 08/12/30

8.0	POWDER COATING	POWDER COATING
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M 105642



(11X)

Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*3:40
320 OF
4:10*

M-L 08/12/30

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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(11)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/12/31

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST 211*

SS 08/12/31 (11)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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(11)

Comment: FINAL INSPECTION/W/O RELEASE

RD 09/01/05

Job Completion



U 01.01.05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		REV. A	
04.06.28		DOUBLER		SHEET 1 OF 1	
A		04.06.28		NEW ISSUE	
				SCALE	
				1:3	

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

DETAIL A
SCALE 2:3

